

ABSTRACT OF THE DISCLOSURE

A multi-layer web formation section has two successive wire units (300, 310) with a common wire (11). A first headbox (100) supplies fiber pulp to the first wire unit (300) forming a first partial web (W1). A second headbox (110) supplies a new fiber pulp layer to the forward end of the second wire unit (310) atop the first partial web.

5 A first non-pulsating dewatering zone (Z1b) in the forward end of a two-wire stretch of the second wire unit (310) has a first formation shoe (200b) with a curved cap (201) placed on the side of the new layer having openings (202) extending through the cap (201) with an under-pressure (P) affecting therethrough. A two-wire stretch

10 of the second wire unit (310) has a second pulsating dewatering zone (Z2b) formed by fixed dewatering lists (210b), between which there are gaps (220b) and an under-pressure (Pb) affecting in these.